

Work Order ID 55334

Page 1

January 13, 2010 10:25:34 AM

Item ID: D3564-9

Accept



Setup Start



Revision ID:

Item Name: Wearshoe

Stop



Start Date: 1/13/10 Start Qty: 10.00



Cust Item ID:

Required Date: 1/20/10 Req'd Qty: 10.00



Customer:

Reference:

Approvals:

Process Plan:

Date: 10-1-13

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
----------	--------------

D3564	Rev D
-------	-------

100



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

I-Cut as per Dwg D3564 ***** (D3564-1F)*****
 Dwg Rev: D Prog
 Rev: D U2-Deburr if necessary



110



QC2- Inspect parts off machine FAI/FAIB

0.00

QC

Memo

0.00

Quality Control

120



QC8- Inspect parts - second check

0.00

QC

Memo

0.00

Quality Control



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Date: Tooling:

Date:

Run Start



QC:

Date: SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130



NC BRAKE

Brake NC

Brake NC

Memo

0.00

0.00

8B

10/01/19

12

140



QC5- Inspect part completeness to step on W/O

0.00

QC

Quality Control

Memo

=> S 10/01/19

0.00

150



Large Fab

0.00

Large Fab

Large Fab

Memo

0.00

Qty	Description	Batch	A/R	2059B Hardcoat
1113521	Weld hardcoat as per Dwg D3564			

BL

10-1-21

X18

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Customer:

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Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

QC10- Inspect visual per QSI004- ground welds

0.00

⇒ Scolahz

0.00

(X/2)



QC

Quality Control

170

QC5- Inspect part completeness to step on W/O

0.00

⇒ Scolahz

0.00

(X/2)



QC

Quality Control

180

Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3

0.00

M1112588

0.00

⇒ 10/01/10



Powdercoat

Powder Coating

Memo

START TIME: 2:00pm OVEN TEMPERATURE:
FINISH TIME: 3:09pm

(X/2)

S

W/O:		WORK ORDER CHANGES					
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Page 4

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Item Name: Wearshoe

Stop



Start Date: 1/13/10 Start Qty: 10.00



Cust Item ID:

Required Date: 1/20/10 Req'd Qty: 10.00



Customer:

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Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

190

QC3- Inspect Part Finish

0.00

BL 10-02-10-

0.00

(12)

QC

Memo

Quality Control

200

Identify as per dwg & Stock Location: FP29

0.00

W 10/02/10

(12)

d

Packaging

Memo

0.00

210

QC21- Final Inspection - Work Order Release

0.00

QC

Memo

0.00

Quality Control

10/02/11 JJ

MF
10-2-11

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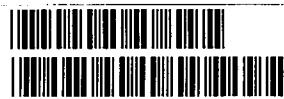
NOTE: Date & initial all entries

Picklist Print

Page 1

January 13, 2010 10:25:38 AM

Work Order ID: 55334



Parent Item: D3564-9



Parent Item Name: Wearshoe

Start Date: 1/13/10

Required Date: 1/20/10

Comments: IPP Rev:A New Issue 07-03-08 ec

Start Qty: 10.00

Required Qty: 10.00

IPP Rev:B As per Rev C 07-07-09 JLM

IPP Rev:C As per Rev D 07-09-09 JLM Verified By:EC

Component Item ID/ M304S16GA	Replacement Purchased	Mfg/ Purchased	Bin No	Primary	Last	Route 100	Unit of sf	Qty on 318.2779	Remaining 11.5789	Qty 14	Date 10-1-18	Status

304/316 Sheet .063

<u>Warehouse</u> <u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
Main Warehouse		
MAT	318.2778737	
106860	8.0295	
111924	25.1689737	
112442	29.8899	
113295	255.1895	13095

(12)

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DART AEROSPACE LTD	Work Order:	55334
Description: Wearshoe	Part Number:	D3564-9
Inspection Dwg: D3564	Rev: D	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Measured by:	<u>B</u>	Audited by:	<u>S</u>	Prototype Approval:	N/A
Date:	10-1-18	Date:	10/01/18	Date:	N/A

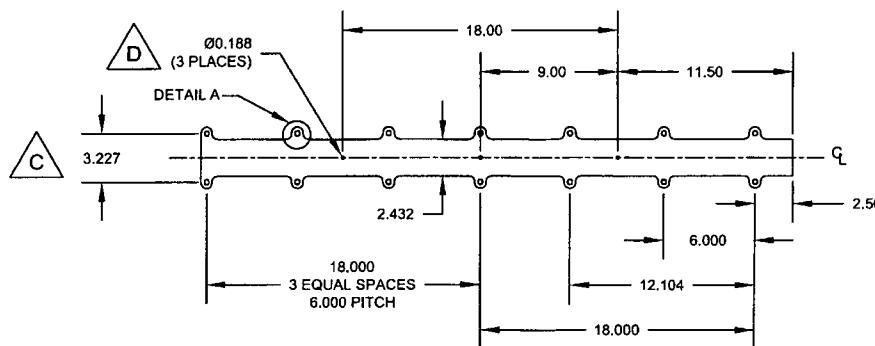
Rev	Date	Change	Revised by	Approved
A	08.01.16	New Issue	KJ/EC/DD	

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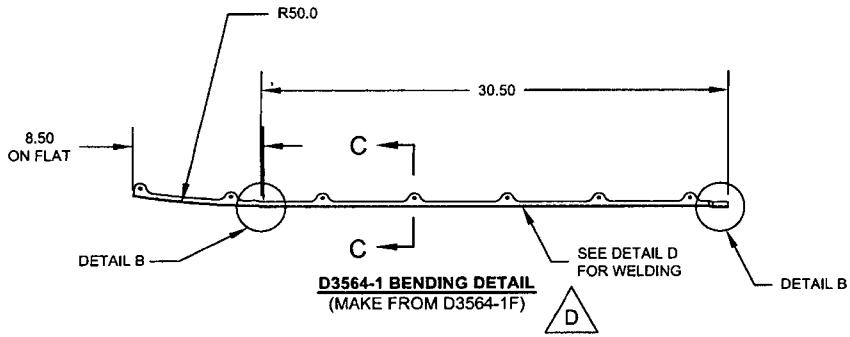
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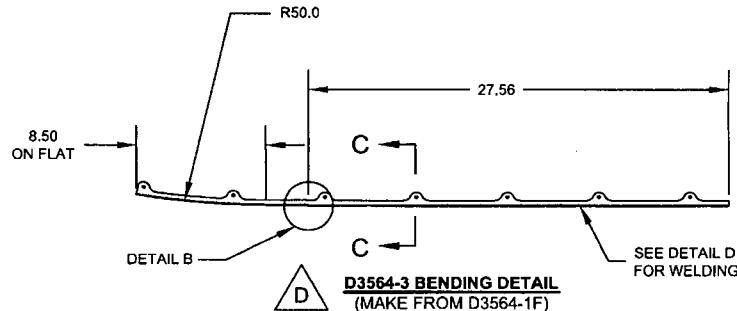


D3564-1F FLAT PATTERN



D3564-1 BENDING DETAIL
(MAKE FROM D3564-1F)

D



**3564-3 BENDING DETAIL
MAKE FROM D3564-1F)**

D3564-1/-3/-5/-7/-9/-11/-13/-15 WEARPLATE NOTES:

1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 16 GAUGE (0.063 THICK)
(REF DART MATERIAL SPEC M304S16GA)

2) FINISH: POWDER COAT GREY SANDTEX (REF 4.3.5.6) PER DART QSI 005 4.3

3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

4) UNITS: INCHES UNLESS OTHERWISE NOTED

5) BREAK SHARP EDGES: .0005 TO 0.015 MAX

6) IDENTIFICATION: NONE

7) WEIGHT: SEE TABLE IN ZONE A3

8) WELD PER DART QSI 004

9) SEE PG 3 FOR SECTIONS AND DETAILS

10) PARTS ARE SYMMETRIC ABOUT C

<u>WEIGHTS:</u>	
D3564-1	1.85 lbs
D3564-3	1.85 lbs
D3564-5	1.93 lbs
D3564-7	1.26 lbs
D3564-9	1.85 lbs
D3564-11	1.85 lbs
D3564-13	0.38 lbs
D3564-15	0.80 lbs

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED CO
SUBJECT TO AMENDMENT

WITHOUT NOTICE
WORK ORDER
NO. 55334

2010-1-13

RELEASED
07.09.04 *[Signature]*

D	UPDATE DRAWING TEMPLATE; CHANGE ALL (TYP X PLS) TO (X PLACES); PG1 A8: UPDATE NOTES; PG1 A8, PG3 B5,C5: ADD D3564-15; PG1 B6,B3: D3564-1/3 WAS ONE FIGURE; PG2 A7,A3: D3564-9/11 WAS ONE FIGURE; PG2 A7,A3: D3564-9/11 WAS ON PG1; PG3 B8,C8: D3564-13 WAS ON PG2; PG3 D2: WELDING DETAIL WAS ON PG1 PG3 A5,7,B2: RELOCATE DETAILS AND SECTION; PG3 A5,7,B2: INCREASE DETAIL AND SECTION SIZE			CB	07.08.21		
	C	MOVE TAB OUTBOARD, DETAIL A			PH	07.04.17	
	B	ADD AMS 5513 AND AMS 5524			PH	07.03.20	
	A	NEW ISSUE			PH	06.12.18	
	REV.	DESCRIPTION			BY	DATE	
	DESIGN	<i>PH</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA				
	DRAWN	<i>CB</i>					
CHECKED	<i>PH</i>	DRAWING NO.			REV. D		
MFG. APPR.	<i>SI</i>	D3564			SHEET 1 OF 3		
APPROVED	<i>MP</i>	TITLE			SCALE		
DE APPR.	<i>SI</i>	WEARSHOE			1:8		
DATE	07.08.21	COPYRIGHT © 2006 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE PROPERTY OF DART AEROSPACE LTD AND IS SUBJECT ON THE EXPRESS CONDITION THAT IT NOT TO BE COPIED FOR ANY PURPOSE OR DISCLOSED TO ANY OTHER PERSON WITHOUT THE WRITTEN PERMISSION FROM DART AEROSPACE LTD.					

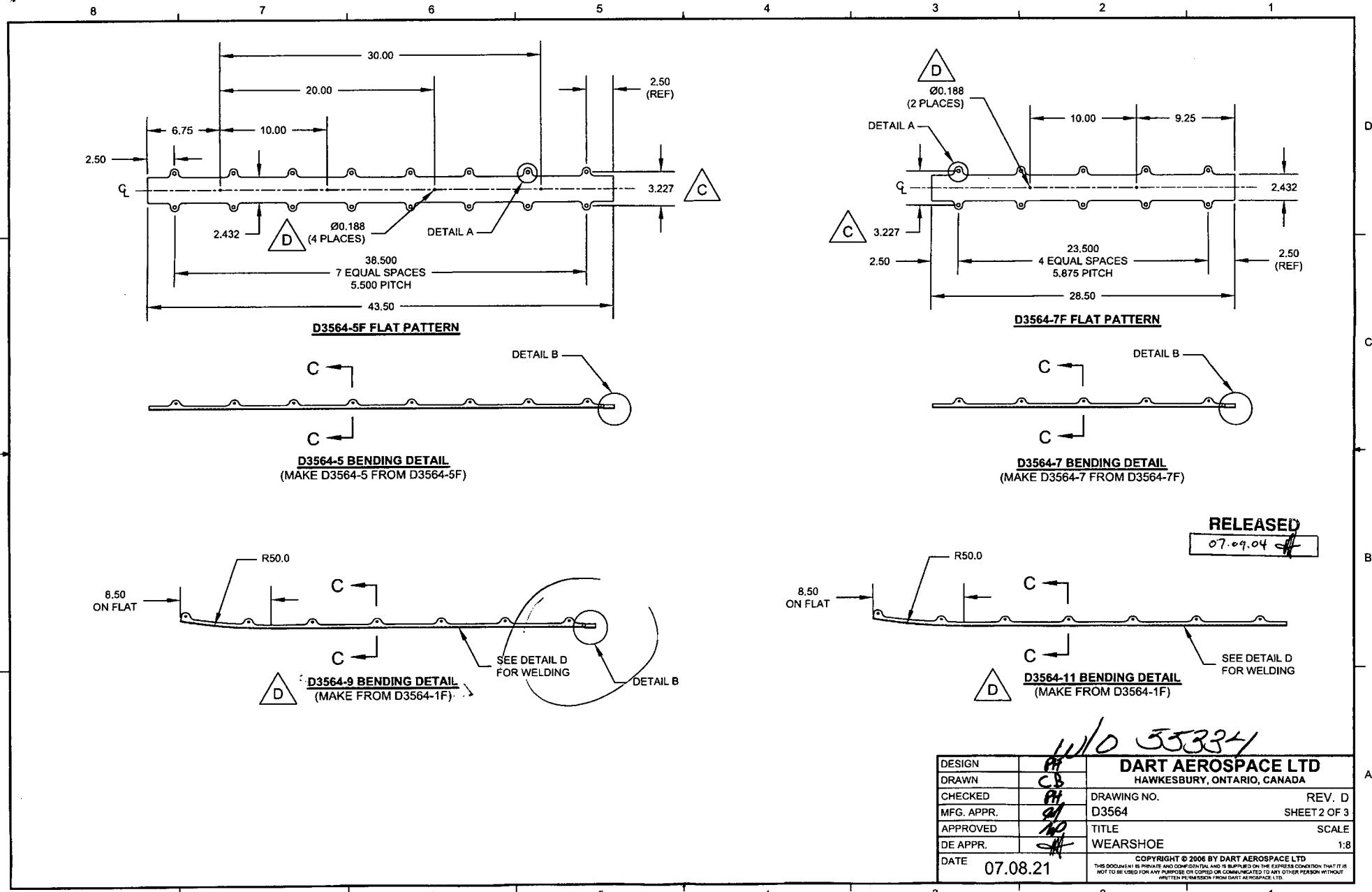
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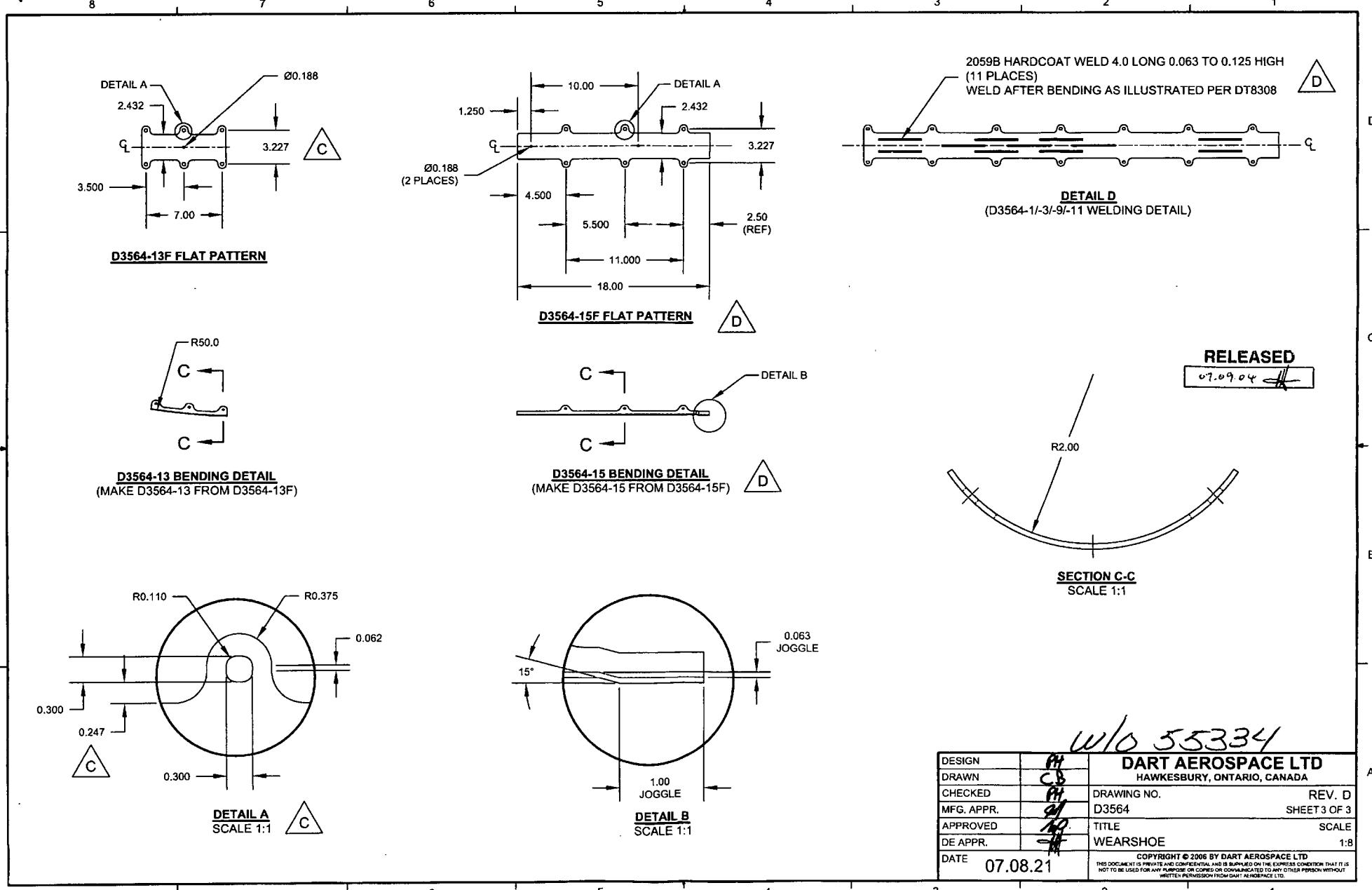


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DESIGN	P4	DART AEROSPACE LTD
DRAWN	CB	HAWKESBURY, ONTARIO, CANADA
CHECKED	PH	REV. D
MFG. APPR.	SH	DRAWING NO. D3564
APPROVED	JP	SHEET 3 OF 3
DE APPR.	SH	TITLE WEARSHOE
DATE	07.08.21	SCALE 1:8

w/o 55334

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